

Date: Wednesday, 17/09/2008 10:46:30 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE
Job Number	: 42054			
Estimate Number	: 13569			
P.O. Number	:		Part Number	: D38141
This Issue	: 17/09/2008	S.O. No. :	Drawing Number	: D3814 PREL
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: / /	Type : MACHINED PARTS	Drawing Revision	: PREL
Previous Run	:		Material	:
Written By	: <i>JLM 08.09.17</i>		Due Date	: 24/09/2008
Checked & Approved By	:		Qty:	3
Comment	: Est Rev:A New Issue 08-09-03 JLM Verified By:EC		Um:	Each

Additional Product

*FOR ENGINEERING USE ONLY**~~PRELIMINARY ISSUE~~*

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B2000X04500	6061T6 Bar 2.00 x 4.500
Comment:	Qty.: 0.6300 ft(s)/Unit Total : 1.8900 ft(s) 6061-T6 Bar 4.00" x 1.00" 2.00 x 4.500" <i>JLM</i>	<i>08/10/02</i>
BATCH:	<i>M109425</i>	(3)
2.0	BAND SAW	BAND SAW
Comment:	BAND SAW Cut blank 7.100 " long	<i>08/10/02</i>
(3)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment:	HAAS CNC VERTICAL MACHINING #1	
1- Mill as per Folio FA780 Rev: <i>A</i> & Dwg D3814 Rev: <i>A</i>		
2-Deburr per dwg D3814		
3-Finish tapping hole to final depth as per Dwg D3814		<i>08/10/02</i>
(3)		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	<i>08/10/02</i>
(3)		
5.0	QC8	SECOND CHECK
Comment:	SECOND CHECK	<i>08/10/03</i>
(2)		

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Seq. #: Machine Or Operation:

Description:

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MJ 08-10-03

(D)

7.0 POWDER COATING POWDER COATING



M1001152

(2X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MASK THREADED HOLE PRIOR TO POWDER COAT

N/A JMF
08-10-03

START TIME: 11:00

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:30

MJ 08/10/03

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AS 08/10/03 (2X)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



HARVEY

POSITIVE RECALL
EFFECTIVE 08-09-03
RELEASED _____

AUTH _____
DATE _____

00252A

DART AEROSPACE LTD	Work Order:	42 054
Description: HINGE	Part Number:	D3814-1
Inspection Dwg: D3814 Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

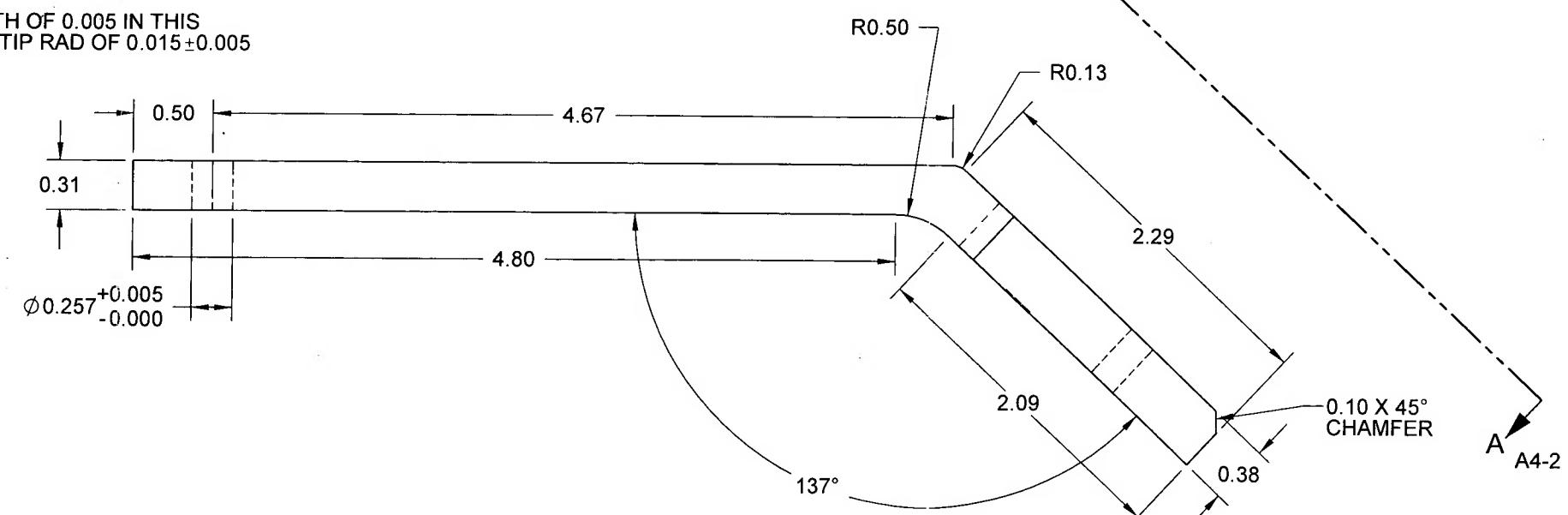
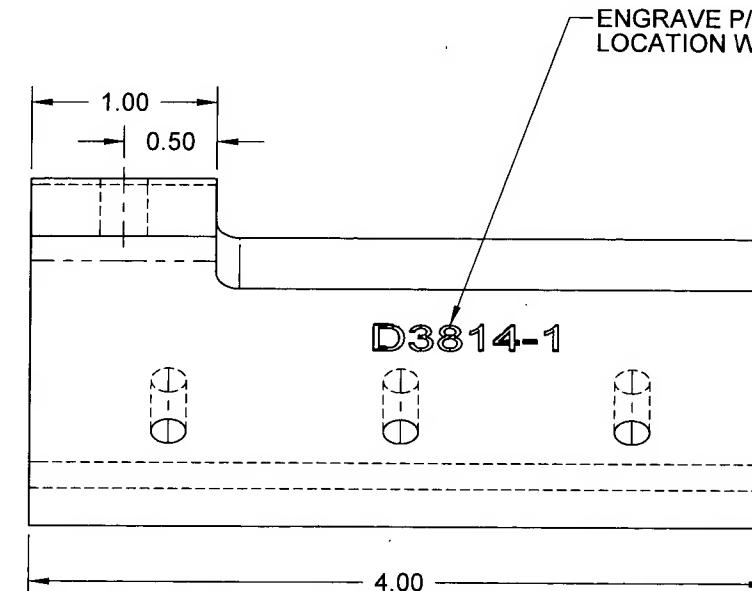
Measured by:	<i>Amil</i>	Audited by:	<i>DJP</i>	Prototype Approval:	
Date:	08/10/02	Date:	08/10/03	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D

D



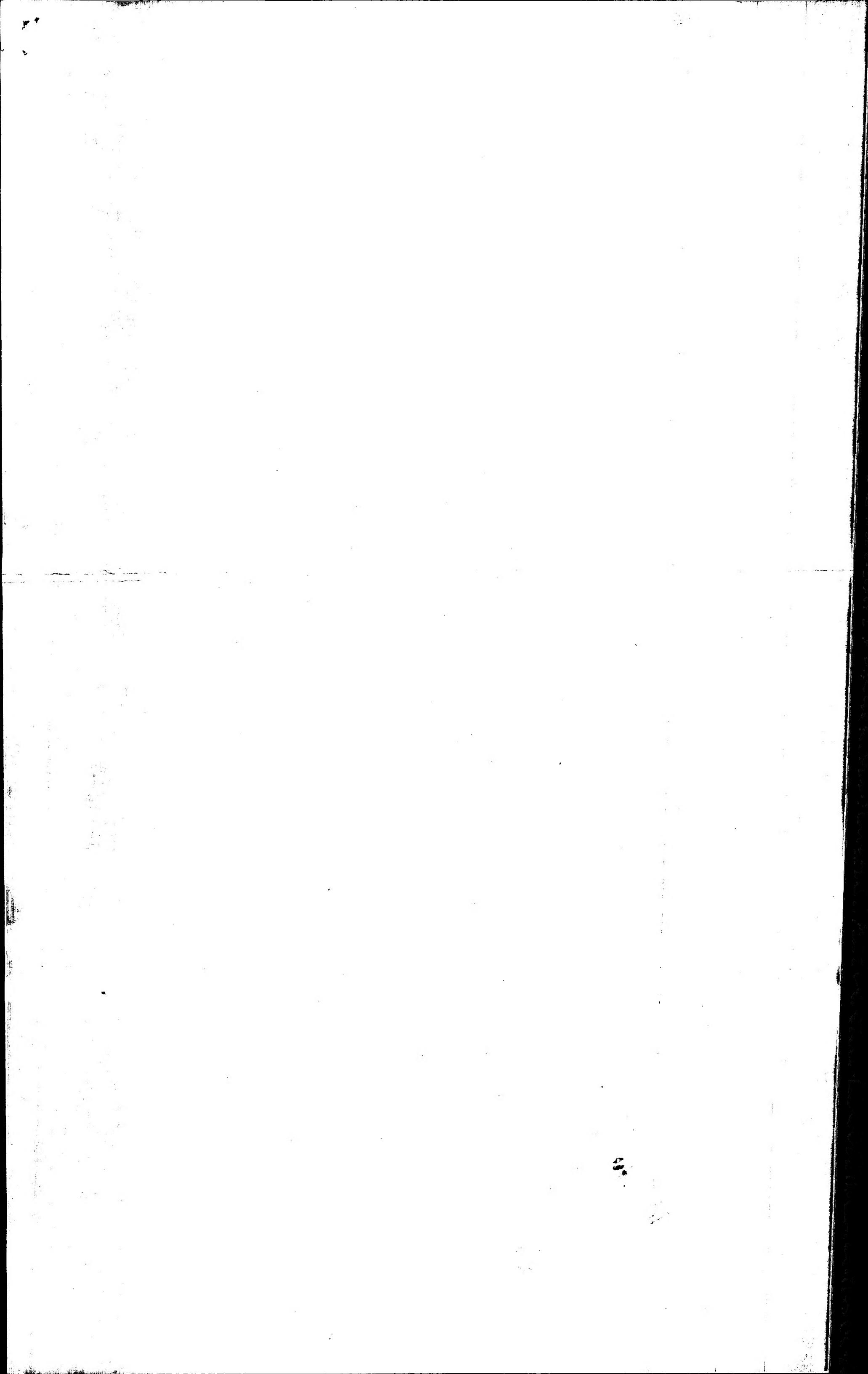
D3814-1 HINGE, UPPER AIRFRAME

PRELIMINARY ISSUE

A NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.44 lbs

A	NEW ISSUE	<i>AS</i>	08.09.11
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3814	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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8 7 6 5 4 3 2 1

D

D

C

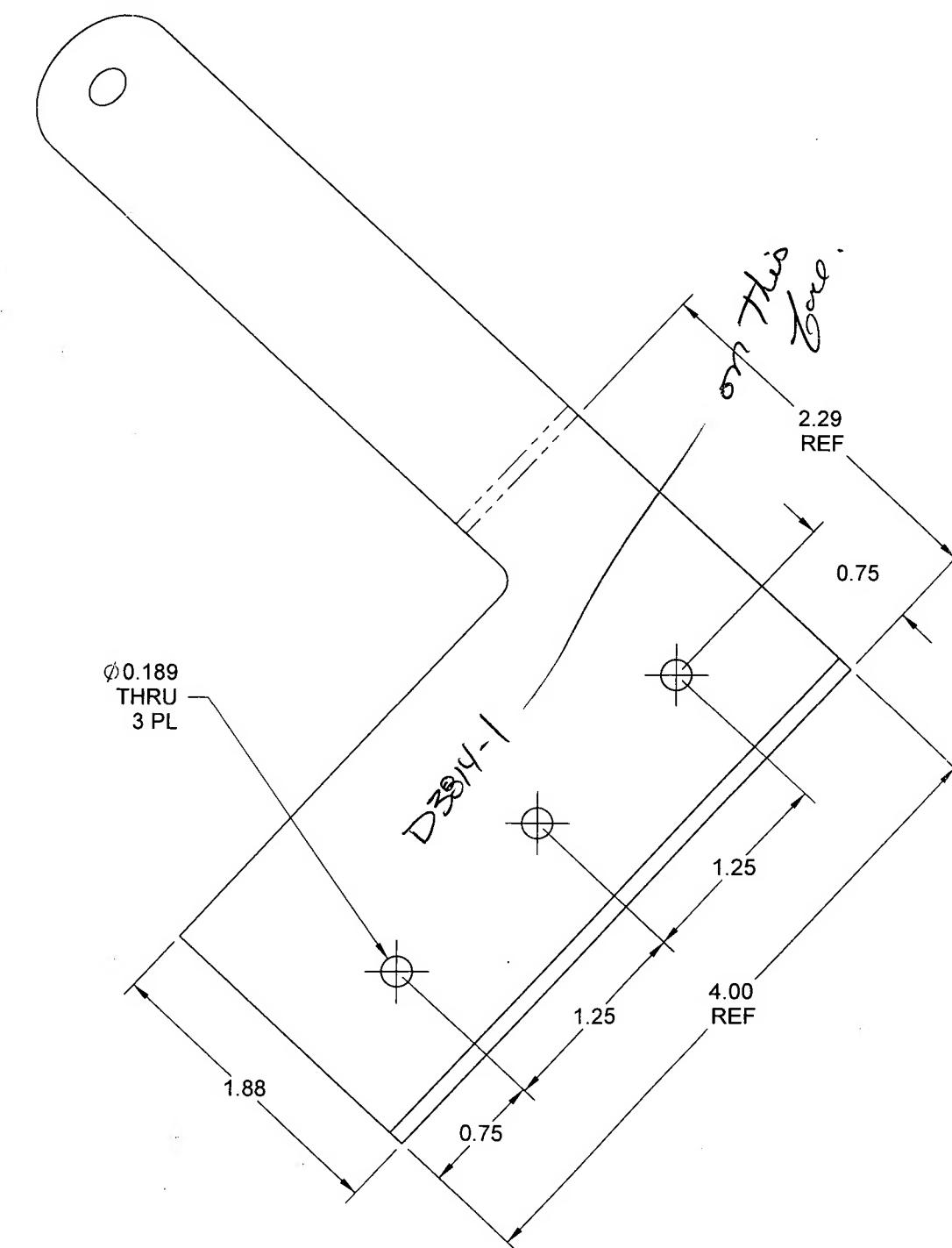
C

B

B

A

A



D3814-1 HINGE, UPPER AIRFRAME

VIEW A-A B1-1

DESIGN	<i>BB</i>	DART AEROSPACE LTD	
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3814	REV. A
APPROVED		SHEET 2 OF 3	
DE APPR.		TITLE	SCALE
		HINGE	NTS
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